

Work Order ID 78102

78102

Page 1

December-28-11 3:33:57 PM

Item ID: D3962-2KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Overhead Corner, RH

Start Date: 28/12/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3962	A

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

Wh
12/01/06

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 4:30 pm

Time OUT: 7:30 am

12/01/05
12/01/06

Wh
12/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

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Start Date: 28/12/2011 **Start Qty:** 1.00 ***1***

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA062 using tool DT9342
Dwg Rev: A
Folio Rev: B

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

OC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
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NS1

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Stop

NS2

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Start Date: 28/12/2011 Start Qty: 1.00

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Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x1

12/01/11

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x1

12/01/12

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/12/01/15

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Start Date: 28/12/2011 Start Qty: 1.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/10

12/1/16

mf
12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

December-28-11 3:34:01 PM

Page 1

Work Order ID: 78102

78102

Parent Item: D3962-2KGY

D3962-2KGY

Parent Item Name: Rear Overhead Corner, RH

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp RevB:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
52068

Purchased

No

100

sf

1,011.893

1

1

MKYD6185S 080-P3-52068

Kydex steel grey

**

Location

Loc Qty

Loc Code

therm

1011.893107

111807

10.4896282

119476

1001.40348

2.5 sq ft

12/01/12

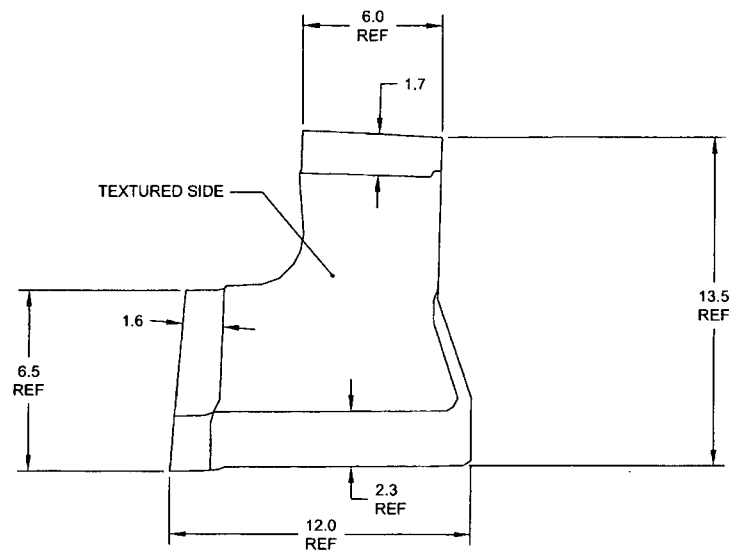
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

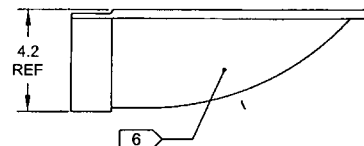
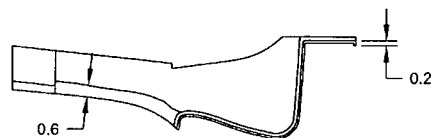
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SIR
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO 78102 M.C.J
11/12/29



D3962-1 REAR OVERHEAD CORNER, LH

RELEASED
09/06/18

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.45 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9341 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	09.06.18
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3962	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	REAR OVERHEAD CORNER (206 L3/L4)	NTS
DATE	09.06.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

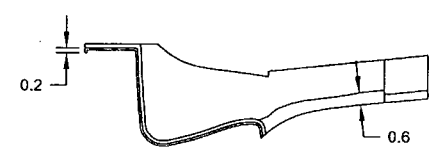
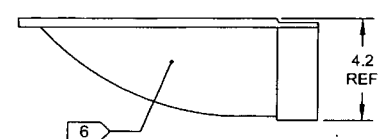
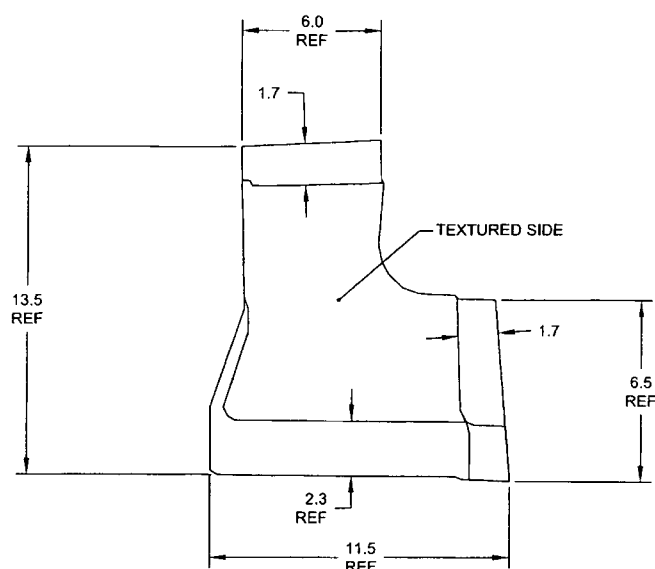
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78102



D3962-2 REAR OVERHEAD CORNER, RH

RELEASED
09/08/25

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.45 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9342 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RE/RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE/RH	DRAWING NO.	REV. A
CHECKED		D3962	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		REAR OVERHEAD CORNER (206 L3/L4)	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.18		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 78102
Description:	Part Number: D3962-2K67
Inspection Dwg: D3962 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{2}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wh

Date: 12/01/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.5	Ref.	13.5"	✓		TAPE DL-01	
11.5	Ref.	11.8"	✓		TAPE DL-01	
6.5	Ref.	7.0"	✓		TAPE DL-01	
6.0	Ref.	7.0"	✓		TAPE DL-01	
1.7	± 0.100	1.75"	✓		Ultr DL-02	
1.7	± 0.100	1.77"	✓		Ultr DL-02	
0.035	MIN.	0.055"	✓		ULTRA	

Measured by: Wh

Date: 12/01/12

Audited by: 8

Date: 12/01/15

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14